

slip 20/06

Work Order ID 102656

\*102656\*

Page 1

Item ID: D117-840-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bearpaw

Start Date: 6/06/13 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 6/10/13 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-06-06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D117-840	A
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100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-840-011 CHG 001

27

B 6 17

2

160

Pick Kit

0.00

\*160\*

Packaging

Memo

0.00

Packaging

13/6/12

M.D. 13-06-10

170

QC4- 100% Inspect kits for completeness

0.00

\*170\*

QC

Memo

0.00

Quality Control

27

B 6 17

2

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td style="width: 33%;">           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </td> <td style="width: 33%;">           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </td> <td style="width: 33%;">           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </td> <td style="width: 33%;">           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 102656

\*102656\*

Page 2

Item ID: D117-840-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bearpaw

Start Date: 6/06/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 6/10/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

\*180\*

Packaging

Packaging

Memo

0.00

Packaging

Identify and mark for shipping as per PPP D117-840-011  
Location: 014  
PPP Rev: \_\_\_\_\_

190

QC21- Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

0.00

Quality Control

MCJ 1306-18

MF 136-17

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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# Picklist Print

June-06-13 8:31:34 AM

Page 1

3

Work Order ID: 102656  
Parent Item: D117-840-011  
Parent Item Name: Bearpaw

Start Date: 6/06/13  
Start Qty: 2.00

Required Date: 6/10/13  
Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-04-01 JLM VERIED BY:DD  
D117-840 REV.A DD VERF:JLM  
IPP REV:B 13.05.28 PER IIN

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274 Radius Block		Manufactured	No				Each	506.0000		16		M.H. 13-06-10	

Location	Loc Qty	Loc Code
FG	2	
85455	12	
86855	2	
ST007	112	
96580	112	
ST008	380	
65047	4	
86855	4	
92418	7	
95118	4	
95412	6	
99005	355	

D3456-1  
Washer

Manufactured No

Each 223.0000

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST047	216	
80252	1	
89237	6	
96570	21	
99338	188	

Shp 2x

16x

24x

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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Doc/Data									
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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
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# Picklist Print

June-06-13 8:31:34 AM

Page 2

Work Order ID: 102656  
Parent Item: D117-840-011  
Parent Item Name: Bearpaw

Start Date: 6/06/13

Required Date: 6/10/13

Start Qty: 2.00

Required Qty: 2.00

D4012-1  
Cushion

Manufactured No

Each 22.0000

SP

8

M.H. 13-06-10

SMB 2

Location	Loc Qty	Loc Code
FG	5	
97172	5	
ST450	2	
92888	2	
ST458	15	
95107	14	
97172	1	

8X

D4796-1  
Bearpaw

Manufactured No

Each 0.0000

SP

4

102658 G

SMB 2

D4798-041

Manufactured No

Each 0.0000

SP

4

B102657 SP

SMB 2

D4799-1

Manufactured No

Each 6.0000

SP

8

M.H. 13-06-14

SMB 2

Clamp

Location	Loc Qty	Loc Code
prelim	6	
99213	6	

B102659

AN4G11A  
bolt

Purchased No

Each 89.0000

SP

24

M.H.

SMB 2

Location	Loc Qty	Loc Code
ST356	89	
121164	20	
121181	69	

24

AN4G17A  
BOLT

Purchased No

Each 196.0000

24

16

M.H.

SMB 2

Location	Loc Qty	Loc Code
ST357	196	
114523	196	

16X

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
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### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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June-06-13 8:31:35 AM

Work Order ID: 102656  
Parent Item: D117-840-011  
Parent Item Name: Bearpaw

Start Date: 6/06/13  
Start Qty: 2.00

Required Date: 6/10/13  
Required Qty: 2.00

**MS21043-4**

Nut

Purchased No

Each 2,240.0000

*SP*

**40**

*M.L. 13-06-10*

*SP 2X*

Location	Loc Qty	Loc Code
FG	36	
104603	36	
GA	2	
121652	2	
ST315	2202	
121162	25	
123021	3	
123525	29	
123900	2	
125654	1187	
m125807	956	

*40x*

**NAST149D0463J**

Washer

Purchased No

Each 3,354.0000

*SP*

**16**

*M.L.*

*SP 2X*

Location	Loc Qty	Loc Code
FP001	2	
122441	2	
ST007	12	
121912	12	
ST294	3340	
119097	8	
124198	221	
124778	3111	

*16x*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

## 4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-840-011	27.7 lb	0.0 in	0.0 lb-in	204.1 in	5653 in-lb
Bearpaw Installation	12.6 kg	0.0 mm	0.0 mm-kg	5200 mm	65,520 mm-kg

## 5.0 PARTS LIST

QTY	Part Number	Description
<del>-011</del>		
X	D117-840-011	BEARPAW INSTALLATION
8	D2274	RADIUS BLOCK
12	D3456-1	WASHER
4	D4012-1	CLAMP CUSHION
2	D4796-1	BEARPAW
2	D4798-041	WEARPLATE ASSY
4	D4799-1	CLAMP
12	AN4C11A	BOLT
8	AN4C17A	BOLT
20	MS21043-4	NUT
8	NAS1149D0463J	WASHER

Ship 20/06

Vork Order ID 102656

\*102656\*

Page 1

me-06-13 8:31:31 AM

em ID: D117-840-011

Accept

\*N9000040100\*

Setup Start \*NS1\*

evision ID:

Stop \*NS2\*

em Name: Bearpaw

Start Date: 6/06/13 Start Qty: 2.00

\*2\*

Cust Item ID:

equired Date: 6/10/13 Req'd Qty: 2.00

\*2\*

Customer:

eference:

pprovals: Process Plan: *ML5*

Date: *13-06-06* Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

equence ID/  
vork Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept  
Qty Reject  
Qty Reject  
Number Insp.  
Stamp

Draw Nbr Revision Nbr

IIN-D117-840

A

00

0.00

\*100\*

DOCUMENT CONTROL

0C

Memo

0.00

ocument Control

Photocopy bluefile & type labels per PPP D117-840-011 CHG 001

*ML5 13-06-10*  
*(2)*

50

Pick Kit

0.00

\*160\*

ackaging

Memo

0.00

ackaging

*ML5 13-06-10*  
*le*

70

QC4- 100% Inspect kits for completeness

0.00

\*170\*

0C

Memo

0.00

uality Control